

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027486**Date Inspected:** 23-Apr-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

This QA Inspector observed ABF welder Rick Clayborn obtain E7018 electrodes from a baking oven early in the am. This QA Inspector requested to measure the temperature of the electrodes and found them to be cold to the touch, as did the welder. This QA Inspector opened the oven door to find it cold as well and verified that it had been off for quite some time. QC Manager Bonifacio Daguinag Jr. requested the oven be emptied and restarted to 500°F for two (2) hours then set to 250°F prior to being placed back in service. ABF welding Supervisor Dan Ieraci informed this QA Inspector that the rod oven had been cleaned out and restarted to the correct temperature. This QA Inspector verified that the oven was at the correct temperature and maintained that temperature throughout the shift.

8W PP70.5 W2-DAH (Interior)

This QA Inspector made random observations of ABF welder Salvador Sandoval (ID 2202) conducting excavation operations of Ultrasonic (UT) rejectable indications on the Deck Access Hole (DAH) located at 8W PP70.5 W2 on the interior of the OBG. The welder was observed utilizing the Carbon Air Arc method as well as a small disc grinder, brushes and compressed air to remove metal from the sites in preparation for testing and inspection. Upon completion of the excavations, QC Inspector Sal Merino performed Magnetic Particle (MT) testing on the two sites to determine the soundness of the metal. It was noted that Mr. Merino found no rejectable

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indications and recorded the dimensions of the excavations as; y+2700mm: 170mm in length, 20mm wide and 8 mm deep, y+3800mm: 150mm in length, 25mm wide and 7mm deep. This QA Inspector made random observations of the in process Shielded Metal Arc Welding (SMAW) of the repairs at the DAH on the interior of the OBG. ABF welder Salvador Sandoval (ID 2202) was observed welding in the 4G overhead position utilizing 3.2mm E7018-H4R electrodes drawing amperage of 119. QC Inspector Sal Merino was observed monitoring the welding and the parameters to ensure compliance to ABF-WPS-D1.5-1001-Repair and measuring the inter-pass temperatures between passes. On a subsequent observation, the welder was observed grinding and blending the edges of the work utilizing a small disc grinder and brushes. This QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work was completed on this date and appeared to be in general conformance to the contract specifications.

FW Spencer Pipe Welding

This QA Inspector observed F.W. Spencer welder Damian LLanos ID# (6645) performing SMAW in all positions on schedule 80, 4" domestic water pipe in the fabrication area to be placed at a later date. The welder also completed installation of a Compressed Air Fitting weld #1/CA2/34/NE. This QA Inspector verified the fit up of the joints and found it to be satisfactory and randomly observed QC Inspector Steve Jensen monitoring the welding to ensure the welding parameters were in compliance pertaining to WPS-1-12-1 Revision 2 (1.12). The welder was observed utilizing 6010 electrodes in the root pass with the balance using 7018 electrodes and cleaning the weld after each pass utilizing a wire wheel on a small disc grinder. The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work appears to be in general conformance with the contract documents.

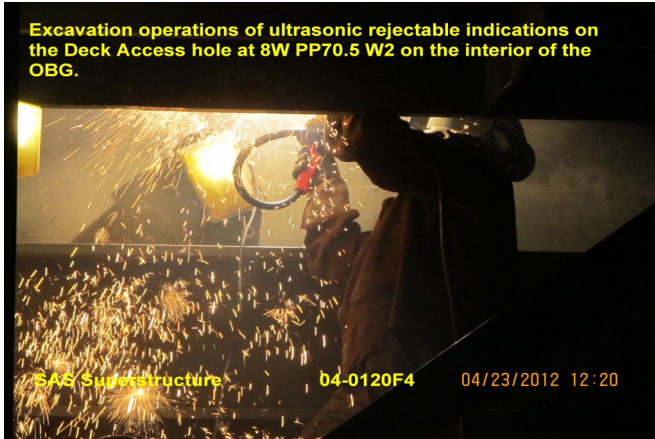
Summary of Conversations:

There were general conversations with QAI Bill Levell and the SMR Bahjat Dagher regarding the Drop-In Panels in relationship to the welding.



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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910 , who represents the Office of Structural Materials for your project.

Inspected By:	Frey,Doug	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
